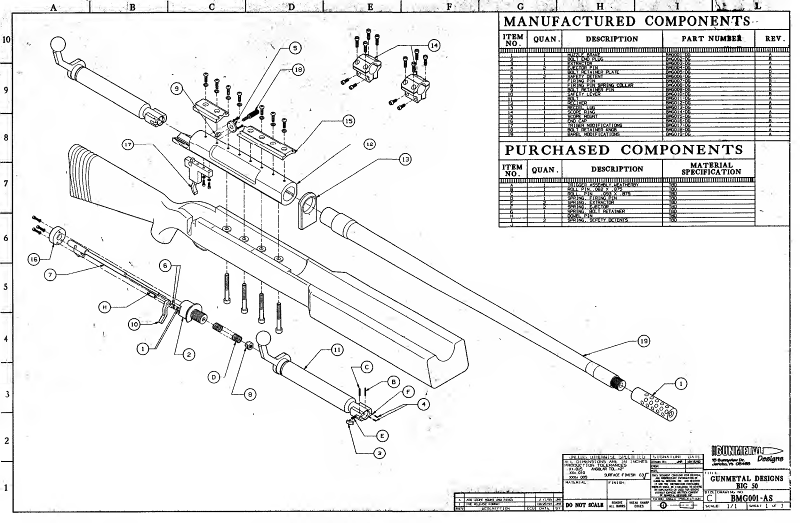


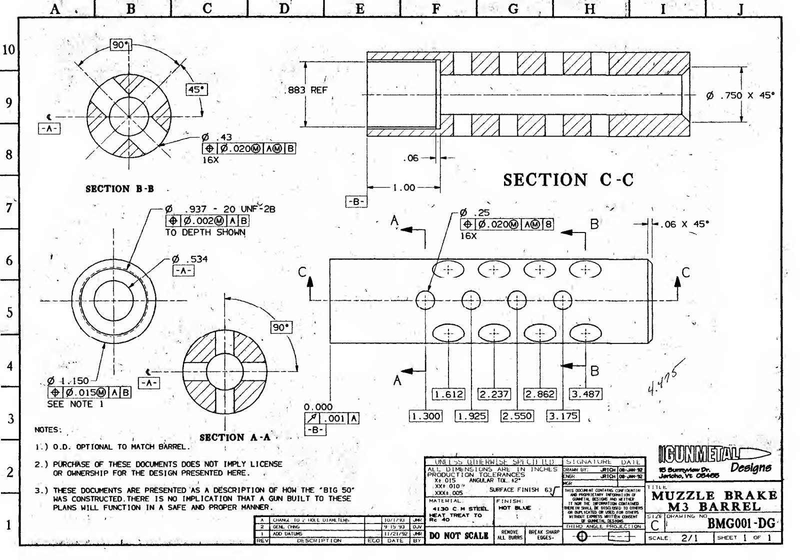
MANUFACTURED COMPONENTS

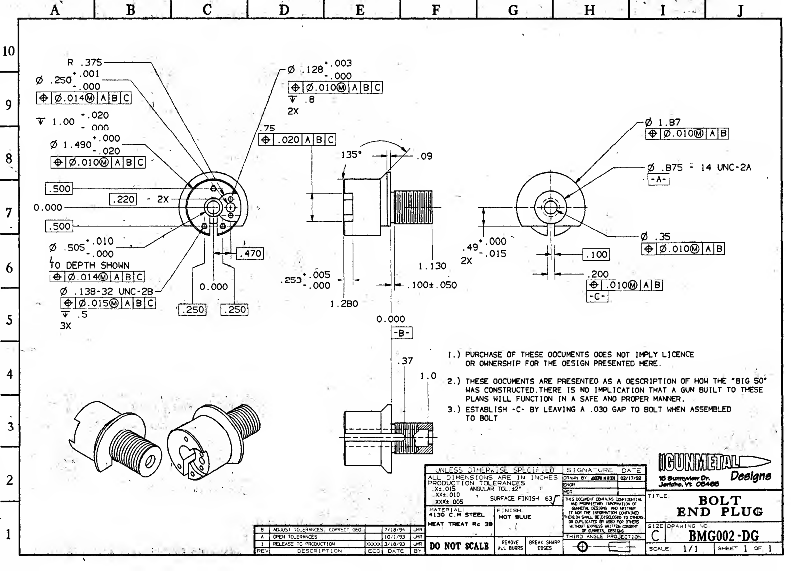
ITEM NO.	QUAN.	DESCRIPTION	PART NUMBER	REV.
1	1	MUZZLE BRAKE	BMG001-DG	A
2	1	BOLT END PLUG	BMG002-DG	B
3	1	EXTRACTOR	BMG003-DG	A
4	2	EJECTOR PIN	BMG004-DG	A
5	1	BOLT RETAINER PLATE	BMG005-DG	D
6	2	SAFETY DETENT	BMG006-DG	B
7	1	FIRING PIN	BMG007-DG	B
8	1	FIRING PIN SPRING COLLAR	BMG008-DG	B
9	1	BOLT RETAINER PIN	BMG009-DG	B
10	1	SAFETY LEVER	BMG010-DG	B
11	1	BOLT	BMG011-DG	A
12	1	RECIVER	BMG012-DG	A
13	1	RECOIL LUG	BMG013-DG	B
14	1	SCOPE RING	BMG014-DG	A
15	1	SCOPE MOUNT	BMG015-DG	B
16	1	END CAP	BMG016-DG	B
17	1	TRIGER MODIFICATIONS	BMG017-DG	A
18	1	BOLT RETAINER KNOB	BMG018-DG	A
19	1	BAREL MODIFICATIONS	BMG019-DG	A

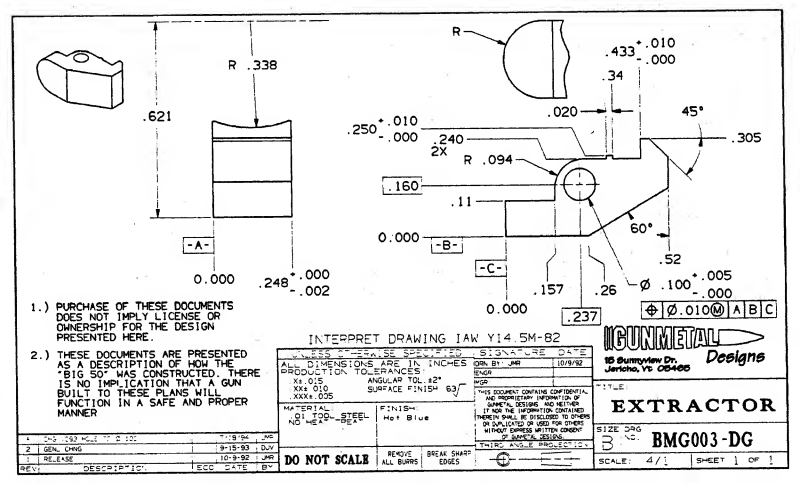
PURCHASED COMPONENTS

ITEM NO.	QUAN.	DESCRIPTION	MATERIAL SPECIFICATION
A	1	TRIGGER ASSEMBLY,WEATHERBY	TBD
B	1	ROLL PIN, .062 X .875	TBD
C	1	ROLL, PIN .093 X .875	TBD
D	1	SPRING, FIRING PIN	TBD
E	2	SPRING, EXTRACTOR	TBD
F	2	SPRING, EJECTOR	TBD
G	1	SPRING, BOLT RETAINER	TBD
H	1	DOWEL PIN	TBD
I	2	SPRING, SEFETY DETENTS	TBD
J			

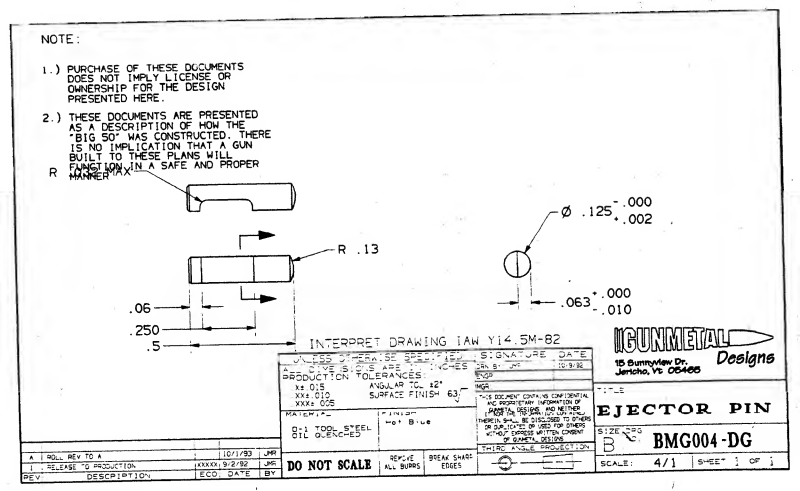
REV	DESCRIPTION	ECU	DATE	BY
A	ADD SCOPE MOUNT AND RINGS		2/1/95	JMR
1	PRE RELEASE FORMAT		10/28/94	JMR

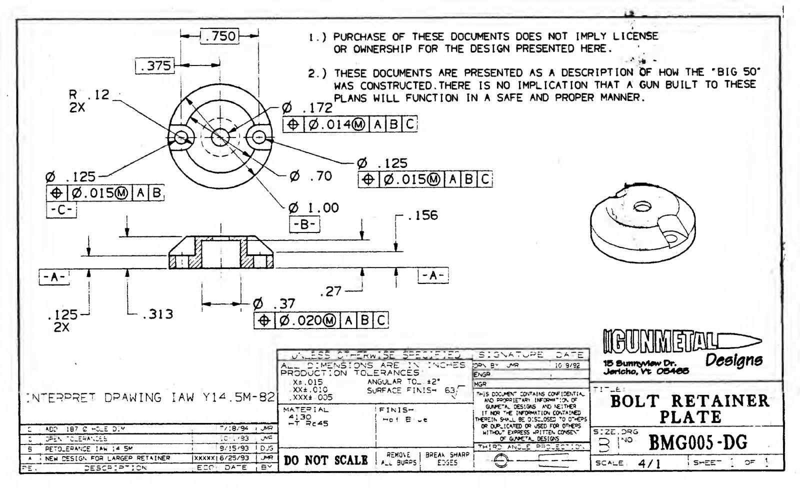

SECTION B-B
90°
45°
-A-
Ø .43
⊕ Ø.020Ⓜ AⓂ B
16X
.883 REF
Ø .750 X 45°
.06
1.00
-B-
SECTION C-C
Ø .937 - 20 UNF-2B
⊕ Ø.002Ⓜ A B
TO DEPTH SHOWN
Ø .534
-A-
Ø .25
⊕ Ø.020Ⓜ AⓂ B
16X
.06 X 45°
A
B
C
C
90°
Ø 1.150
⊕ Ø.015Ⓜ A B
SEE NOTE 1
-A-
SECTION A-A
0.000
↗ .001 A
-B-
1.612
2.237
2.862
3.487
1.300
1.925
2.550
3.175
4.475
NOTES:
1.) O.D. OPTIONAL TO MATCH BARREL.
2.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENSE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.
3.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
A CHANGE TO 2 HOLE DIAMETERS 10/1/93 JMR
2 GENL CHNG 9 15 93 DJV
1 ADD DATUMS 11/21/92 JMR
REV DESCRIPTION ECO DATE BY
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
X± .015 ANGULAR TOL ±2°
.XX± .010
.XXX± .005
SURFACE FINISH 63
MATERIAL
4130 C M STEEL
HEAT TREAT TO Rc 40
FINISH
HOT BLUE
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES.
SIGNATURE DATE
DRAWN BY JRICH 08-JAN-92
ENGR JRICH 08-JAN-92
MGR
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
MUZZLE BRAKE
M3 BARREL
SIZE C
DRAWING NO
BMG001-DG
SCALE 2/1
SHEET 1 OF 1


R .375
Ø .250 +.001 -.000
⊕ Ø.014Ⓜ A B C
↧ 1.00 +.020 -.000
Ø 1.490 +.000 -.020
⊕ Ø.010Ⓜ A B C
.500
.220 - 2X
0.000
.500
Ø .505 +.010 -.000
TO DEPTH SHOWN
⊕ Ø.014Ⓜ A B C
Ø .138-32 UNC-2B
⊕ Ø.015Ⓜ A B C
↧ .5
3X
0.000
.470
.250
.250
Ø .128 +.003 -.000
⊕ Ø.010Ⓜ A B C
↧ .8
2X
.75
⊕ .020 A B C
135°
.09
1.130
.253 +.005 -.000
.100±.050
1.280
0.000
-B-
.37
1.0
Ø 1.87
⊕ Ø.010Ⓜ A B
Ø .875 - 14 UNC-2A
-A-
.49 +.000 -.015
2X
.100
Ø .35
⊕ Ø.010Ⓜ A B
.200
⊕ .010Ⓜ A B
-C-
1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENCE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.
2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
3.) ESTABLISH -C- BY LEAVING A .030 GAP TO BOLT WHEN ASSEMBLED TO BOLT
B | ADJUST TOLERANCES, CORRECT GEO | 7/18/94 | JMR
A | OPEN TOLERANCES | 10/1/93 | JMR
1 | RELEASE TO PRODUCTION | XXXXX | 3/18/93 | JMR
REV | DESCRIPTION | ECO | DATE | BY
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
.X± .015 ANGULAR TOL. ±2°
.XX± .010
.XXX± .005
SURFACE FINISH 63
MATERIAL 4130 C.M STEEL
HEAT TREAT Rc 38
FINISH HOT BLUE
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRAWN BY JOSEPH M RICH 02/17/92
ENGR
MGR
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE BOLT END PLUG
SIZE C
DRAWING NO BMG002-DG
SCALE 1/1
SHEET 1 OF 1

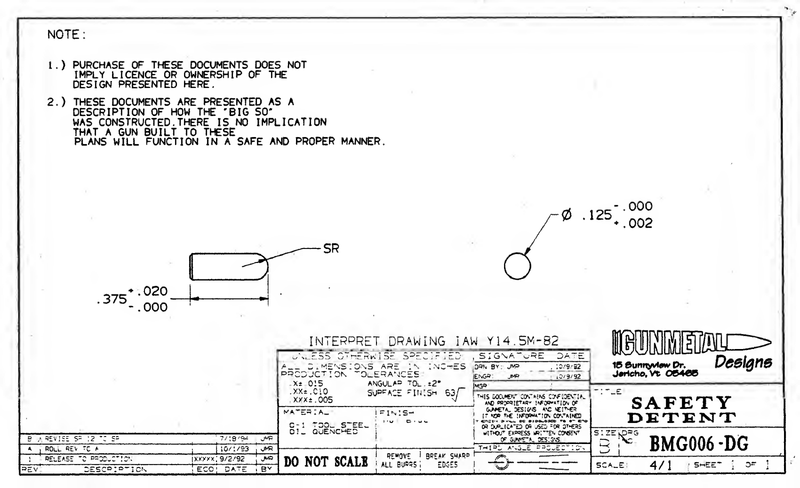


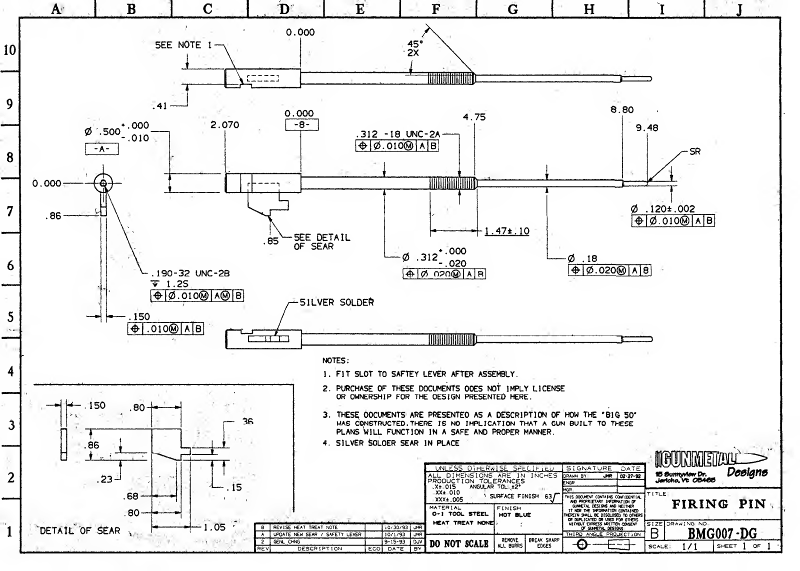
R .338
.621
-A-
0.000
.248 +.000 -.002
R
.433 +.010 -.000
.34
.020
45°
.250 +.010 -.000
.240 2X
.305
R .094
.160
.11
60°
0.000
-B-
.52
-C-
.157
.26
Ø .100 +.005 -.000
0.000
.237
Ø .010 Ⓜ A B C
1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENSE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.
2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER
INTERPRET DRAWING IAW Y14.5M-82
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES:
.X±.015
.XX±.010
.XXX±.005
ANGULAR TOL. ±2°
SURFACE FINISH 63
SIGNATURE DATE
DRN BY: JMR 10/9/92
ENGR
MGR
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE:
EXTRACTOR
MATERIAL:
.01 TOOL STEEL
NO HEAT TREAT
FINISH:
Hot Blue
SIZE DRG NO.
B
BMG003-DG
4 CHG .093 HOLE TO Ø .100 7/18/94 JMR
2 GEN. CHNG 9-15-93 DJV
1 RELEASE 10-9-92 JMR
REV DESCRIPTION ECO DATE BY
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SCALE: 4/1
SHEET 1 OF 1


NOTE:
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R .032 MAX
R .13
Ø .125 -.000 +.002
.063 +.000 -.010
.06
.250
.5
INTERPRET DRAWING IAW Y14.5M-82
UNLESS OTHERWISE SPECIFIED
PRODUCTION TOLERANCES
X± .015
XX± .010
XXX± .005
ANGULAR TOL ±2°
SURFACE FINISH 63
MATERIAL
O-1 TOOL STEEL
OIL QUENCHED
FINISH
Hot Blue
SIGNATURE
DATE
DRN BY JMR
10/9/92
ENGR
MGR
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THIRD ANGLE PROJECTION
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
EJECTOR PIN
SIZE B
BMG004-DG
SCALE: 4/1
SHEET 1 OF 1
A | ROLL REV TO A | | 10/1/93 | JMR
1 | RELEASE TO PRODUCTION | XXXXX | 9/2/92 | JMR
REV | DESCRIPTION | ECO | DATE | BY

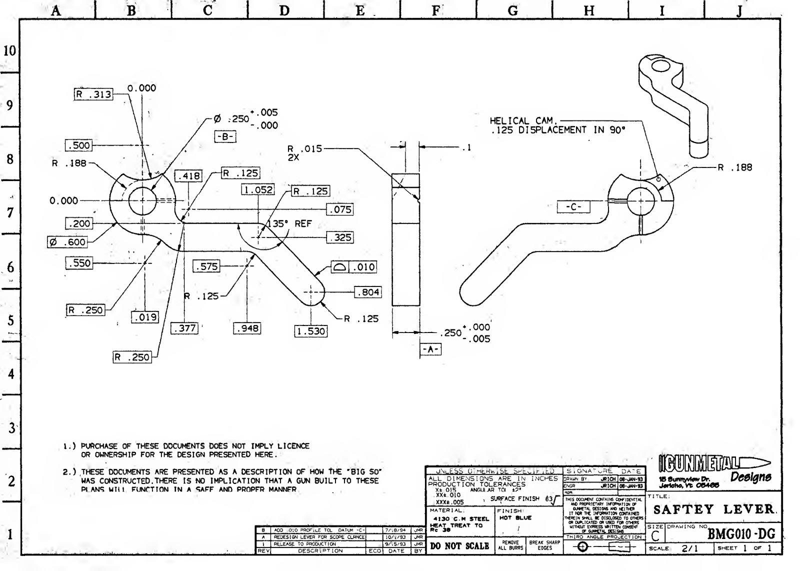


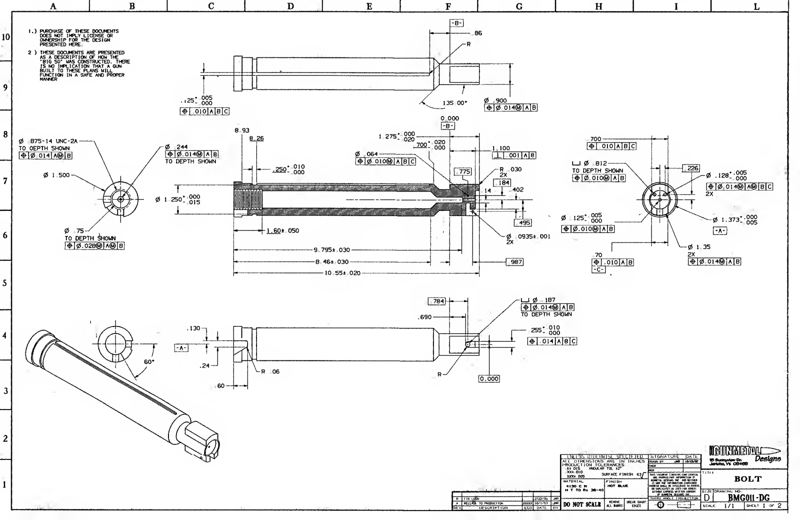
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2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
.750
.375
R .12
2X
Ø .172
⊕ Ø.014Ⓜ A B C
Ø .125
⊕ Ø.015Ⓜ A B C
Ø .125
⊕ Ø.015Ⓜ A B
-C-
Ø .70
Ø 1.00
-B-
.156
-A-
-A-
.27
Ø .37
⊕ Ø.020Ⓜ A B C
.125
2X
.313
INTERPRET DRAWING IAW Y14.5M-82
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
.X±.015
.XX±.010
.XXX±.005
ANGULAR TOL ±2°
SURFACE FINISH 63
MATERIAL
4130
HT Rc45
FINISH
Hot Blue
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRN BY JMR 10/9/92
ENGR
MGR
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE:
BOLT RETAINER PLATE
SIZE B
DRG NO BMG005-DG
SCALE 4/1
SHEET 1 OF 1
D ADD .187 Ø HOLE DIM 7/18/94 JMR
C OPEN TOLERANCES 10/1/93 JMR
B RETOLERANCE IAW 14.5M 9/15/93 DJG
A NEW DESIGN FOR LARGER RETAINER XXXXX 6/25/93 JMR
REV. DESCRIPTION ECO DATE BY


NOTE:
1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENCE OR OWNERSHIP OF THE DESIGN PRESENTED HERE.
2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
SR
.375 +.020 -.000
Ø .125 -.000 +.002
INTERPRET DRAWING IAW Y14.5M-82
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
.X± .015
.XX±.010
.XXX±.005
ANGULAR TOL. ±2°
SURFACE FINISH 63
SIGNATURE DATE
DRN BY: JMP 10/9/92
ENGR: JMR 10/9/92
MGR
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THIRD ANGLE PROJECTION
MATERIAL
O-1 TOOL STEEL
OIL QUENCHED
FINISH
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
SAFETY DETENT
SIZE B
DRG NO
BMG006-DG
SCALE 4/1
SHEET 1 OF 1
B REVISE SR .12 TO SR 7/18/94 JMR
A ROLL REV TO A 10/1/93 JMR
1 RELEASE TO PRODUCTION XXXXX 9/2/92 JMR
REV DESCRIPTION ECO DATE BY

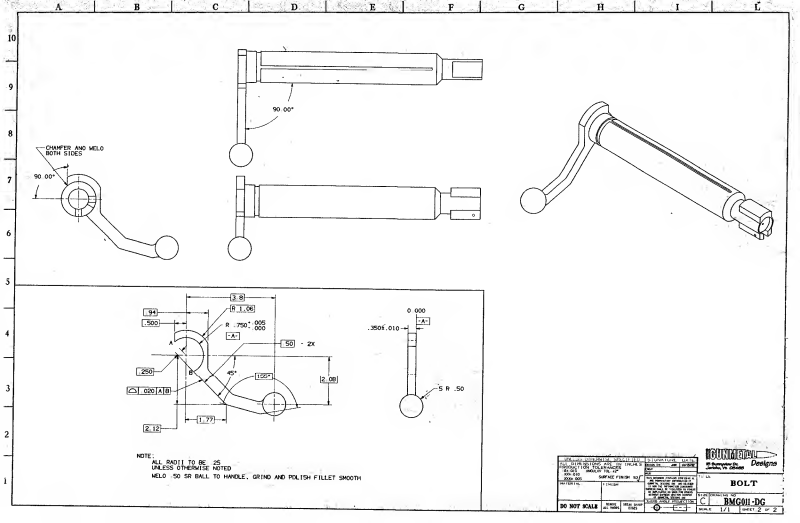


A
B
C
D
E
F
G
H
I
J
10
9
8
7
6
5
4
3
2
1
0.000
SEE NOTE 1
45°
2X
.41
0.000
-8-
2.070
4.75
8.80
9.48
Ø .500 +.000 -.010
-A-
.312 -18 UNC-2A
⊕ Ø.010Ⓜ A B
SR
0.000
.86
Ø .120±.002
⊕ Ø.010Ⓜ A B
1.47±.10
.85
SEE DETAIL OF SEAR
Ø .312 +.000 -.020
⊕ Ø .020Ⓜ A B
Ø .18
⊕ Ø.020Ⓜ A B
.190-32 UNC-2B
↧ 1.25
⊕ Ø.010Ⓜ AⓂ B
SILVER SOLDER
.150
⊕ .010Ⓜ A B
NOTES:
1. FIT SLOT TO SAFTEY LEVER AFTER ASSEMBLY.
2. PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENSE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.
3. THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
4. SILVER SOLOER SEAR IN PLACE
.150
.80
.36
.86
.23
.15
.68
.80
1.05
DETAIL OF SEAR
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
.X± .015 ANGULAR TOL ±2°
.XX± .010
.XXX± .005
SURFACE FINISH 63
MATERIAL
O-1 TOOL STEEL
HEAT TREAT NONE
FINISH
HOT BLUE
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRAWN BY JMR 02-27-92
ENGR
MGR
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
FIRING PIN
SIZE B
DRAWING NO
BMG007-DG
SCALE 1/1
SHEET 1 OF 1
B REVISE HEAT TREAT NOTE 10/30/93 JMR
A UPDATE NEW SEAR / SAFETY LEVER 10/1/93 JMR
2 GENL CHNG 9-15-93 DJV
REV DESCRIPTION ECO DATE BY

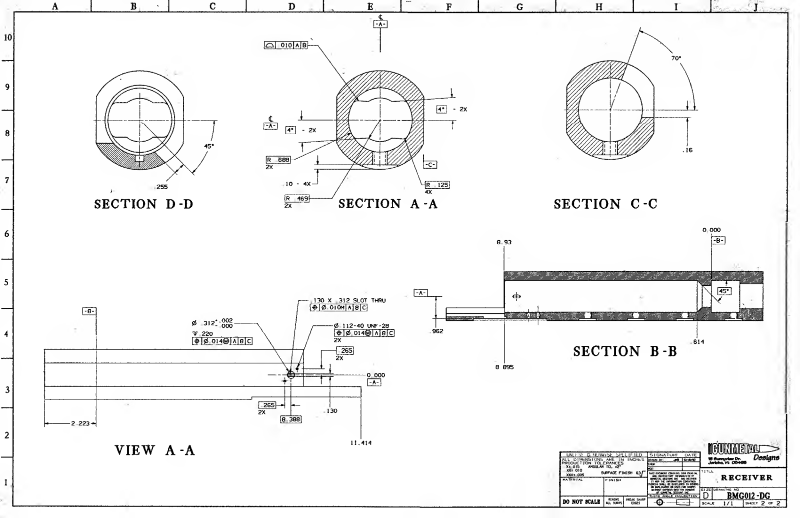

A B C D E F G H I J
10 9 8 7 6 5 4 3 2 1
R .313
0.000
Ø .250 +.005 -.000
-B-
.500
R .188
.418
R .125
1.052
R .125
0.000
.075
.200
135° REF
.325
Ø .600
.550
.575
.010
.804
R .125
R .250
.019
.377
.948
1.530
R .125
R .250
R .015 2X
.1
.250 +.000 -.005
-A-
HELICAL CAM.
.125 DISPLACEMENT IN 90°
R .188
-C-
1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENCE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.
2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
B | ADD .010 PROFILE TOL DATUM -C- | 7/18/94 | JMR
A | REDESIGN LEVER FOR SCOPE CLRNCE | 10/1/93 | JMR
1 | RELEASE TO PRODUCTION | 9/15/93 | JMR
REV | DESCRIPTION | ECO | DATE | BY
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
X± .015 ANGULAR TOL ±2°
XX± .010
XXX± .005
SURFACE FINISH 63
MATERIAL: 4130 C.M STEEL HEAT TREAT TO Rc 38
FINISH: HOT BLUE
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRAWN BY JRICH 08-JAN-93
ENGR JRICH 08-JAN-93
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE: SAFTEY LEVER.
SIZE C
DRAWING NO. BMG010-DG
SCALE 2/1
SHEET 1 OF 1



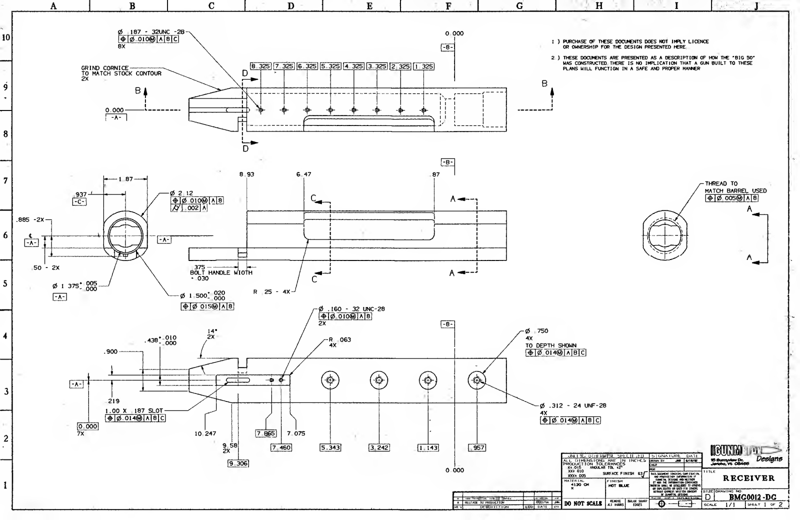
1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENSE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.
2) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER
-B-
.86
R
.125 +.005 -.000
135.00°
Ø .900
Ø .875-14 UNC-2A TO DEPTH SHOWN
Ø .244 TO DEPTH SHOWN
Ø 1.500
Ø .75 TO DEPTH SHOWN
8.93
8.26
.250 +.010 -.000
Ø 1.250 +.000 -.015
1.60±.050
9.795±.030
8.46±.030
10.55±.020
1.275 +.000 -.020
.700 +.020 -.000
Ø .064
1.100
.775
R .030 2X
.184
.14
.402
.495
Ø .0935±.001 2X
.987
.700
Ø .812 TO DEPTH SHOWN
.226
Ø .128 +.005 -.000 2X
Ø .125 +.005 -.000
Ø 1.373 +.000 -.005
-A-
.70
-C-
Ø 1.35 2X
.784
.690
Ø .187 TO DEPTH SHOWN
.255 +.010 -.000
.130
.24
R .06
.60
R
0.000
60°
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
.X± .015 ANGULAR TOL ±2°
.XX± .010
.XXX± .005
SURFACE FINISH 63
MATERIAL 4130 C M H T TO Rc 38-40
FINISH HOT BLUE
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRAWN BY JMR 10/15/92
ENGR
MGR
THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr. Jericho, Vt 05465
TITLE BOLT
SIZE D
DRAWING NO. BMG011-DG
SCALE 1/1
SHEET 1 OF 2
B FIX LOGO 2/22/96 JMR
A RELEASE TO PRODUCTION XXXXX 10/1/93 JMR
REV DESCRIPTION ECO DATE BY



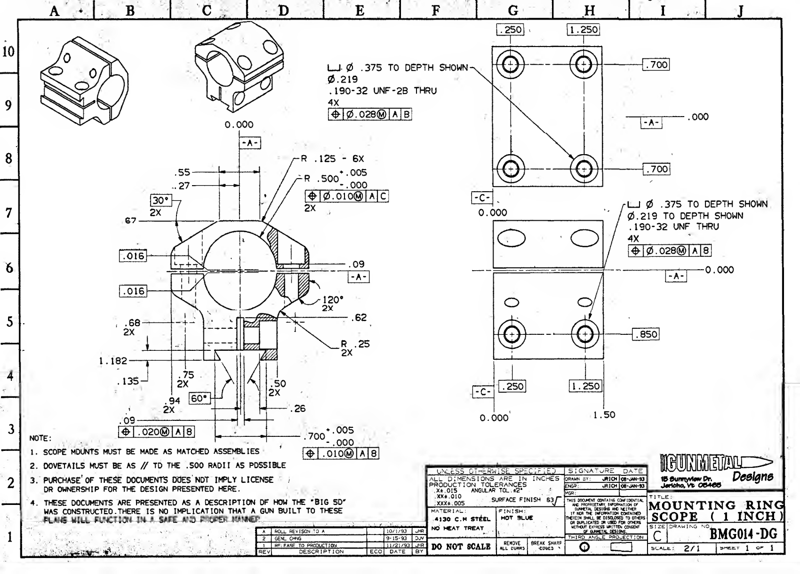
A
B
C
D
E
F
G
H
I
L
10
9
8
7
6
5
4
3
2
1
CHAMFER ANO WELO BOTH SIDES
90.00°
90.00°
3.8
.94
R 1.06
.500
R .750 +.005 -.000
-A-
A
.50 - 2X
.250
B
45°
155°
2.08
⌓ .020 A B
1.77
2.12
0.000
-A-
.350±.010
5 R .50
NOTE:
ALL RADII TO BE .25 UNLESS OTHERWISE NOTED
WELO .50 SR BALL TO HANDLE, GRIND AND POLISH FILLET SMOOTH
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
X± .015 ANGULAR TOL ±2°
XX± .010
XXX± .005
SURFACE FINISH 63
MATERIAL
FINISH
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRAWN BY JHR 10/15/92
ENGR
MGR
THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
BOLT
SIZE C
DRAWING NO
BMG011-DG
SCALE 1/1
SHEET 2 OF 2



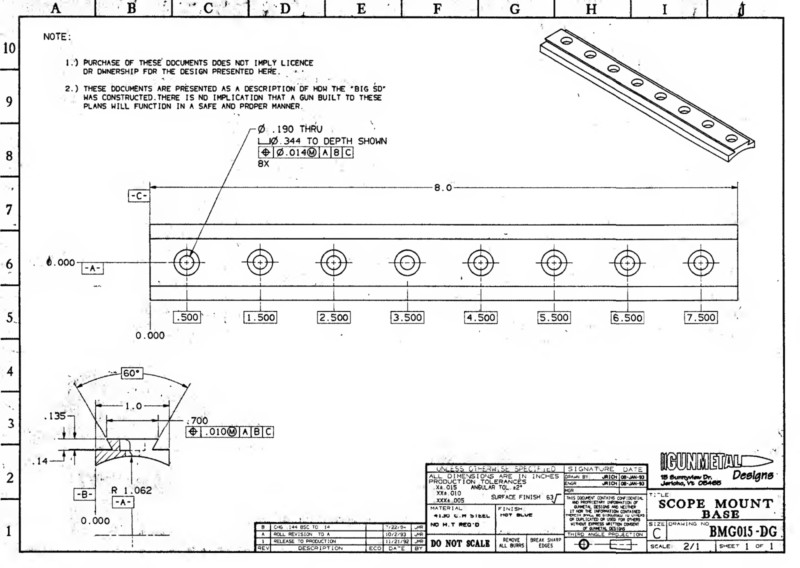
SECTION D-D
45°
.255
SECTION A-A
.010 A B
4° - 2X
R .688
2X
.10 - 4X
R .469
2X
-C-
R .125
4X
-A-
SECTION C-C
70°
.16
SECTION B-B
0.000
-B-
8.93
45°
-A-
.962
.614
8.895
VIEW A-A
-B-
Ø .312 +.002 -.000
.220
Ø .014 Ⓜ A B C
.130 X .312 SLOT THRU
Ø .010 Ⓜ A B C
Ø .112-40 UNF-2B
Ø .014 Ⓜ A B C
2X
.265
2X
0.000
-A-
.265
2X
8.388
.130
2.223
11.414
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
X± .015 ANGULAR TOL ±2°
XX± .010
XXX± .005
SURFACE FINISH 63
MATERIAL
FINISH
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRAWN BY JHR 6/18/92
ENGR
MGR
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Bunnyview Dr.
Jericho, Vt 05465
TITLE
RECEIVER
SIZE D
DRAWING NO
BMG012-DG
SCALE 1/1
SHEET 2 OF 2



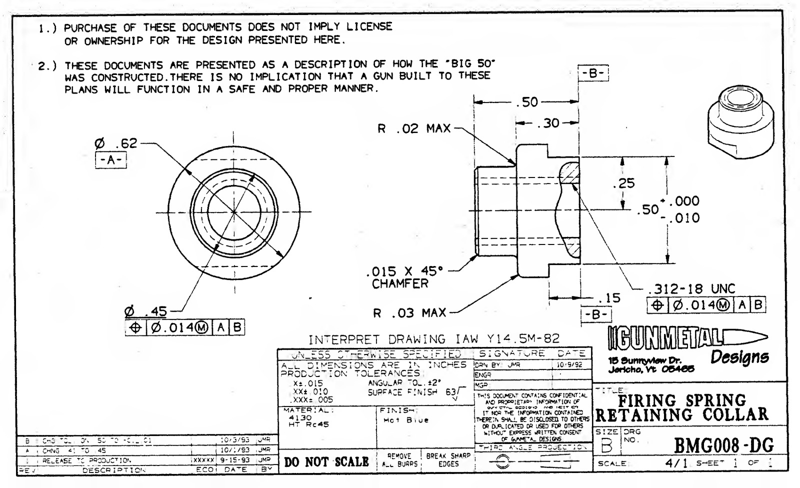
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2) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER
Ø .187 - 32UNC -28
8X
GRIND CORNICE TO MATCH STOCK CONTOUR
2X
8.325
7.325
6.325
5.325
4.325
3.325
2.325
1.325
0.000
-A-
-B-
THREAD TO MATCH BARREL USED
Ø 2.12
1.87
.937
-C-
.885 -2X
.50 - 2X
Ø 1.375
Ø 1.500
8.93
6.47
.87
.375
BOLT HANDLE WIDTH
R .25 - 4X
Ø .160 - 32 UNC-28
2X
R .063
4X
Ø .750
4X
TO DEPTH SHOWN
14°
2X
.438
.900
.219
1.00 X .187 SLOT
7X
10.247
9.58
2X
9.306
7.865
7.075
7.460
5.343
3.242
1.143
.957
Ø .312 - 24 UNF-28
4X
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
X± .015 ANGULAR TOL ±2°
XX± .010
XXX± .005
SURFACE FINISH 63
MATERIAL
4130 CM
FINISH
HOT BLUE
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRAWN BY JMR
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
RECEIVER
SIZE D
DRAWING NO
BMG0012 -DG
SCALE 1/1
SHEET 1 OF 2

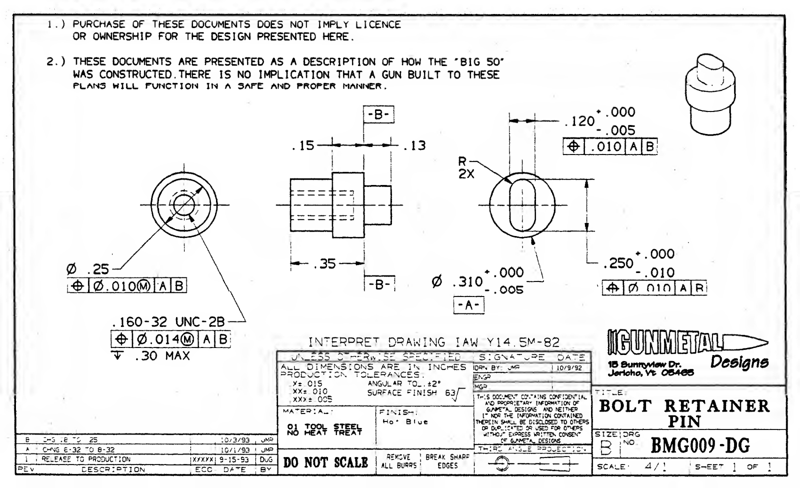


NOTE:
1. SCOPE MOUNTS MUST BE MADE AS MATCHED ASSEMBLIES
2. DOVETAILS MUST BE AS // TO THE .500 RADII AS POSSIBLE
3. PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENSE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.
4. THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
⌴ Ø .375 TO DEPTH SHOWN
Ø.219
.190-32 UNF-2B THRU
4X
⌖ Ø.028Ⓜ A B
⌴ Ø .375 TO DEPTH SHOWN
Ø.219 TO DEPTH SHOWN
.190-32 UNF THRU
4X
⌖ Ø.028Ⓜ A B
R .125 - 6X
R .500 +.005 -.000
⌖ Ø.010Ⓜ A C
2X
30° 2X
120° 2X
60°
R .25 2X
⌖ .020Ⓜ A B
.700 +.005 -.000
⌖ .010Ⓜ A B
-A-
-C-
0.000
.250
1.250
.700
.850
1.50
1.182
.135
.55
.27
.67
.016
.09
.62
.68 2X
.75 2X
.94 2X
.50 2X
.26
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
.X± .015 ANGULAR TOL. ±2°
.XX± .010
.XXX± .005
SURFACE FINISH 63
MATERIAL: 4130 C.M STEEL
NO HEAT TREAT
FINISH: HOT BLUE
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRAWN BY: JRICH 08-JAN-93
ENGR: JRICH 08-JAN-93
MGR:
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr. Jericho, Vt 05465
TITLE: MOUNTING RING SCOPE (1 INCH)
SIZE C
DRAWING NO. BMG014-DG
SCALE: 2/1
SHEET 1 OF 1
A ROLL REVISON TO A 10/1/93 JMR
2 GENL CHNG 9-15-93 DJV
1 RELEASE TO PRODUCTION 11/21/93 JMR
REV DESCRIPTION ECO DATE BY

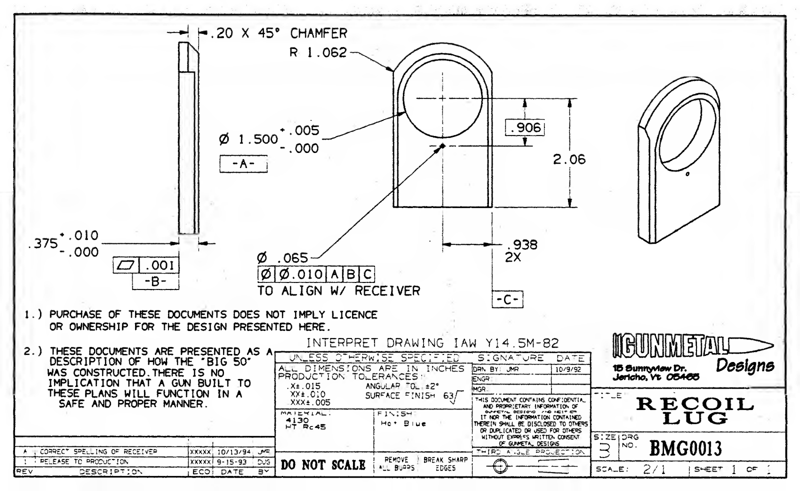


A
B
C
D
E
F
G
H
I
J
10
9
8
7
6
5
4
3
2
1
NOTE:
1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENCE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.
2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG SD" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
Ø .190 THRU
⌴ Ø.344 TO DEPTH SHOWN
⌖ Ø.014Ⓜ A B C
8X
8.0
-C-
0.000
-A-
.500
1.500
2.500
3.500
4.500
5.500
6.500
7.500
0.000
60°
1.0
.700
⌖ .010Ⓜ A B C
.135
.14
R 1.062
-B-
-A-
0.000
B | CHG .144 BSC TO .14 | 7/22/94 | JMR
A | ROLL REVISION TO A | 10/2/93 | JMR
1 | RELEASE TO PRODUCTION | 11/21/92 | JMR
REV | DESCRIPTION | ECO | DATE | BY
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
X± .015 ANGULAR TOL ±2°
XX± .010
XXX± .005
SURFACE FINISH 63
MATERIAL
4130 C.M STEEL
NO H.T REQ'D
FINISH
HOT BLUE
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRAWN BY JRICH 08-JAN-93
ENGR JRICH 08-JAN-93
MGR
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
SCOPE MOUNT BASE
SIZE C
DRAWING NO BMG015-DG
SCALE 2/1
SHEET 1 OF 1

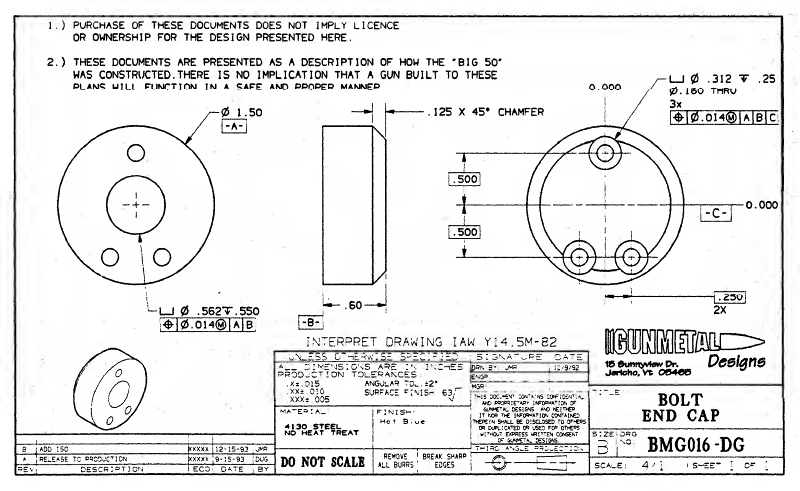

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2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
Ø .62
-A-
Ø .45
⊕ Ø.014Ⓜ A B
-B-
.50
.30
R .02 MAX
.25
.50 +.000 -.010
.015 X 45° CHAMFER
R .03 MAX
.15
-B-
.312-18 UNC
⊕ Ø.014Ⓜ A B
INTERPRET DRAWING IAW Y14.5M-82
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
.X±.015
.XX±.010
.XXX±.005
ANGULAR TOL. ±2°
SURFACE FINISH 63
MATERIAL:
4130
HT Rc45
FINISH:
Hot Blue
SIGNATURE DATE
DRN BY JMR 10/9/92
ENGR
MGR
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IT NOR THE INFORMATION CONTAINED THEREIN SHALL BE DISCLOSED TO OTHERS OR DUPLICATED OR USED FOR OTHERS WITHOUT EXPRESS WRITTEN CONSENT OF GUNMETAL DESIGNS
THIRD ANGLE PROJECTION
TITLE
FIRING SPRING RETAINING COLLAR
SIZE B
DRG NO. BMG008-DG
SCALE 4/1
SHEET 1 OF 1
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
REV | DESCRIPTION | ECO | DATE | BY
B | CHG TOL ON .50 TO +0/-.01 | | 10/3/93 | JMR
A | CHNG .41 TO .45 | | 10/1/93 | JMR
1 | RELEASE TO PRODUCTION | XXXXX | 9-15-93 | JMR



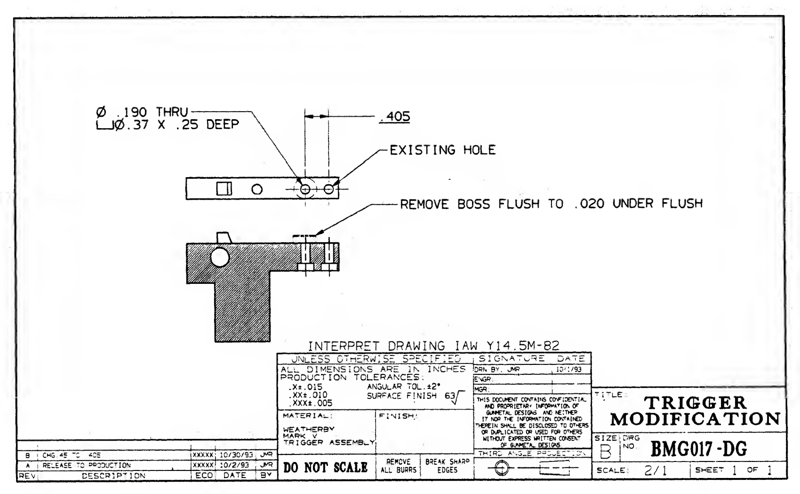
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2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
-B-
.15
.13
.35
-B-
Ø .25
⊕ Ø.010Ⓜ A B
.160-32 UNC-2B
⊕ Ø.014Ⓜ A B
↧ .30 MAX
R
2X
.120 +.000 -.005
⊕ .010 A B
Ø .310 +.000 -.005
-A-
.250 +.000 -.010
⊕ Ø .010 A B
INTERPRET DRAWING IAW Y14.5M-82
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES:
.X± .015
.XX± .010
.XXX± .005
ANGULAR TOL. ±2°
SURFACE FINISH 63
SIGNATURE DATE
DRN BY: JMR 10/9/92
ENGR
MGR
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THIRD ANGLE PROJECTION
MATERIAL:
01 TOOL STEEL
NO HEAT TREAT
FINISH:
Hot Blue
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
B CHG .18 TO .25 10/3/93 JMR
A CHNG 6-32 TO 8-32 10/1/93 JMR
1 RELEASE TO PRODUCTION XXXXX 9-15-93 DJG
REV DESCRIPTION ECO DATE BY
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE:
BOLT RETAINER PIN
SIZE B
DRG NO. BMG009-DG
SCALE 4/1
SHEET 1 OF 1

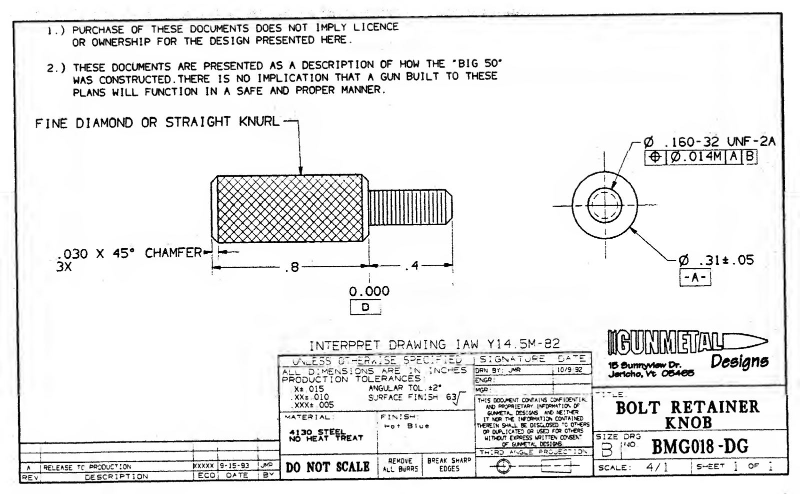


.20 X 45° CHAMFER
R 1.062
Ø 1.500 +.005 -.000
-A-
.906
2.06
.375 +.010 -.000
.001
-B-
Ø .065
Ø Ø.010 A B C
TO ALIGN W/ RECEIVER
.938 2X
-C-
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INTERPRET DRAWING IAW Y14.5M-82
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES:
.X±.015
XX±.010
XXX±.005
ANGULAR TOL ±2°
SURFACE FINISH 63
MATERIAL:
4130
HT Rc45
FINISH:
Hot Blue
SIGNATURE DATE
DRN BY: JMR 10/9/92
ENGR
MGR
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
RECOIL LUG
SIZE B
DRG NO. BMG0013
SCALE: 2/1
SHEET 1 OF 1
A CORRECT SPELLING OF RECEIVER XXXXX 10/13/94 JMR
1 RELEASE TO PRODUCTION XXXXX 9-15-93 DWG
REV DESCRIPTION ECO DATE BY
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES

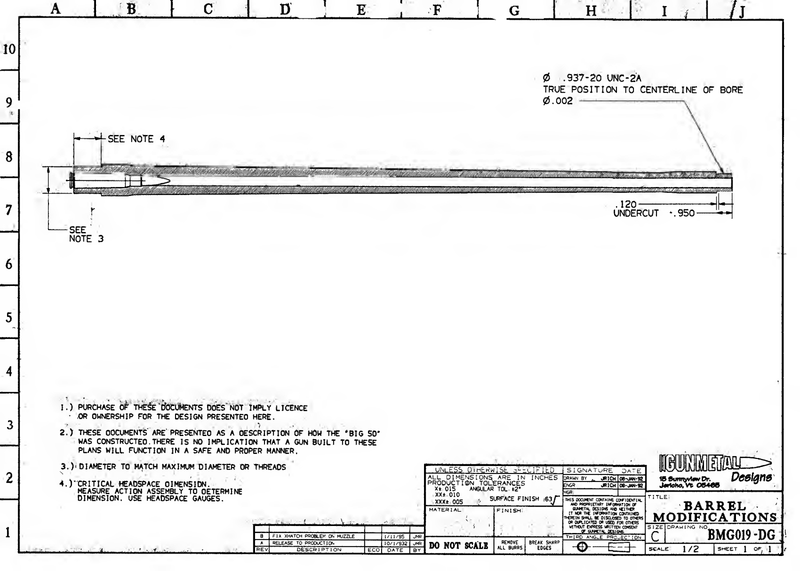


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Ø 1.50
-A-
.125 X 45° CHAMFER
0.000
Ø .312 ↧ .25
Ø.180 THRU
3x
⊕ Ø.014Ⓜ A B C
.500
.500
0.000
-C-
.250
2X
Ø .562↧.550
⊕ Ø.014Ⓜ A B
.60
-B-
INTERPRET DRAWING IAW Y14.5M-82
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
.X± .015
.XX± .010
.XXX± .005
ANGULAR TOL. ±2°
SURFACE FINISH 63
SIGNATURE DATE
DRN BY: JMR 10/9/92
ENGR.
MGR.
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GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
BOLT END CAP
MATERIAL
4130 STEEL NO HEAT TREAT
FINISH:
Hot Blue
SIZE B
DRG NO. BMG016-DG
B ADD ISO XXXXX 12-15-93 JMR
A RELEASE TO PRODUCTION XXXXX 9-15-93 DUG
REV DESCRIPTION ECO DATE BY
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
THIRD ANGLE PROJECTION
SCALE: 4/1
SHEET 1 OF 1


Ø .190 THRU
⌴Ø.37 X .25 DEEP
.405
EXISTING HOLE
REMOVE BOSS FLUSH TO .020 UNDER FLUSH
INTERPRET DRAWING IAW Y14.5M-82
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES:
.X±.015
.XX±.010
.XXX±.005
ANGULAR TOL.±2°
SURFACE FINISH 63√
MATERIAL:
WEATHERBY
MARK V
TRIGGER ASSEMBLY
FINISH:
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRN BY. JMR
ENGR
MGR
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THIRD ANGLE PROJECTION
TITLE:
TRIGGER MODIFICATION
SIZE B
DRG NO.
BMG017-DG
SCALE: 2/1
SHEET 1 OF 1
B CHG .45 TO .405 XXXXX 10/30/93 JMR
A RELEASE TO PRODUCTION XXXXX 10/2/93 JMR
REV DESCRIPTION ECO DATE BY



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2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
FINE DIAMOND OR STRAIGHT KNURL
Ø .160-32 UNF-2A
Ø.014M A B
.030 X 45° CHAMFER
3X
.8
.4
0.000
D
Ø .31±.05
-A-
INTERPRET DRAWING IAW Y14.5M-82
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES:
.X± .015
.XX± .010
.XXX± .005
ANGULAR TOL. ±2°
SURFACE FINISH 63
MATERIAL:
4130 STEEL
NO HEAT TREAT
FINISH:
Hot Blue
SIGNATURE DATE
DRN BY: JMR 10/9/92
ENGR:
MGR:
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
BOLT RETAINER KNOB
SIZE B
DRG NO BMG018-DG
SCALE: 4/1
SHEET 1 OF 1
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
A RELEASE TO PRODUCTION XXXXX 9-15-93 JMR
REV DESCRIPTION ECO DATE BY


A B C D E F G H I J
10 9 8 7 6 5 4 3 2 1
Ø .937-20 UNC-2A
TRUE POSITION TO CENTERLINE OF BORE
Ø.002
SEE NOTE 4
SEE
NOTE 3
.120
UNDERCUT .950
1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENCE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.
2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
3.) DIAMETER TO MATCH MAXIMUM DIAMETER OR THREADS
4.) CRITICAL HEADSPACE DIMENSION. MEASURE ACTION ASSEMBLY TO DETERMINE DIMENSION. USE HEADSPACE GAUGES.
B FIX XHATCH PROBLEM ON MUZZLE 1/11/95 JMR
A RELEASE TO PRODUCTION 10/1/932 JMR
REV DESCRIPTION ECO DATE BY
UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES
X± .015 ANGULAR TOL ±2°
XX± .010
XXX± .005 SURFACE FINISH 63
MATERIAL
FINISH
DO NOT SCALE
REMOVE ALL BURRS
BREAK SHARP EDGES
SIGNATURE DATE
DRAWN BY JRICH 08-JAN-92
ENGR JRICH 08-JAN-92
MGR
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THIRD ANGLE PROJECTION
GUNMETAL Designs
15 Sunnyview Dr.
Jericho, Vt 05465
TITLE
BARREL MODIFICATIONS
SIZE C
DRAWING NO. BMG019-DG
SCALE 1/2
SHEET 1 OF 1